GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:33:53 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 32076		
Estimate Number	: 10530		
P.O. Number	: N/A	**Part Number**	: D2571
This Issue	: 4/26/2007 **S.O. No.** : N/A	**Drawing Number**	: D2571 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 31806	**Material**	: N/A
Written By	:	**Due Date**	: 5/30/2007 **Qty:** 10 **Um:** Each
Checked & Approved By	: 07.04.26		
Comment	: Est: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B 25353 mk/07/05/28 10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 32076 Double check by: J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

mk/ Er 07/05/30 (X 10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572 mk/ Er 07/05/30 (X10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE mk/ Er 07/05/30 (X10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ☐ **Date:** 07/06/05

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 3:33:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 32076 **Part Number:** D2571

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	SA 07.05.30
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	07.05.30 (10)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat OLIVE DRAB GREEN (Ref: 4.3.5.1) as per QSI 005 4.3	m104476 07/06/05 (10)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	07/06/05 (10)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	07/06/05 (10)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/06/05 (10)

Job Completion

07/06/05

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32076
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443	~~DT8682~~	0.439	0.439	0.438	0.439		
B	1.745	1.755		1.748	1.749	1.749	1.748		
C	3.495	3.505		3.499	3.499	3.500	3.499		
D	1.745	1.755		1.748	1.749	1.749	1.748		
E	7.990	8.010		8.000	8.006	8.004	8.004		
F	0.490	0.510		0.503	0.505	0.503	0.504		
G	0.257	0.262	~~DT8686~~	0.258	0.258	0.258	0.258		
H	0.375	0.380	~~DT8684~~	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.502	0.503	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.493		
N	2.495	2.505		2.498	2.499	2.499	2.499		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.251	0.250		
S	0.115	0.135		0.136	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.243	0.243	0.244		
W	0.115	0.135		0.121	0.120	0.121	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.761	0.761	0.760		
Z	0.352	0.372		0.365	0.365	0.366	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.629	0.633	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.251	0.253	0.252		
AE	1.375	1.395		1.385	1.386	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.250	0.253		
AI	2.000	2.020		2.001	2.002	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	JMK
Date:	07/05/28

Audited by	KJ
Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32076
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
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A	0.438	0.443	~~DT8682~~	0.439	0.440	0.440	0.446		
B	1.745	1.755		1.749	1.745	1.749	1.747		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.745	1.749	1.747		
E	7.990	8.010		8.001	8.001	8.002	8.001		
F	0.490	0.510		0.502	0.500	0.502	0.502		
G	0.257	0.262	~~DT8683~~	0.258	0.258	0.260	0.260		
H	0.375	0.380	~~DT8684~~	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.500	0.502		
J	1.174	1.184		1.177	1.177	1.175	1.175		
K	0.558	0.578		0.568	0.568	0.566	0.566		
L	1.174	1.184		1.177	1.177	1.175	1.175		
M	1.490	1.500		1.493	1.493	1.492	1.494		
N	2.495	2.505		2.499	2.499	2.497	2.496		
O	3.869	3.879		3.871	3.871	3.871	3.870		
P	0.115	0.135		0.126	0.126	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.130	0.130	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.243	0.242	0.244		
W	0.115	0.135		0.120	0.120	0.121	0.119		
X	0.308	0.313		0.311	0.311	0.310	0.311		
Y	0.760	0.765		0.760	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.622	0.622	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.253	0.246	0.246		
AE	1.375	1.395		1.387	1.385	1.386	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.245	0.245	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.247	0.248		
AI	2.000	2.020		2.001	2.001	2.000	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	GM / GD
Date:	07/05/29

Audited by	SD
Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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H	0.375	0.380	~~DT8684~~	0.377	0.377				
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J	1.174	1.184		1.175	1.176				
K	0.558	0.578		0.567	0.564				
L	1.174	1.184		1.175	1.176				
M	1.490	1.500		1.495	1.494				
N	2.495	2.505		2.497	2.497				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.126	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.251	0.250				
S	0.115	0.135		0.126	0.123				
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U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.239	0.241				
W	0.115	0.135		0.123	0.121				
X	0.308	0.313		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0366	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.621	0.622				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.245	0.246				
AE	1.375	1.395		1.388	1.387				
AF	0.115	0.135		0.135	0.135				
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AH	0.240	0.260		0.279	0.251				
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Date:	07/05/30

Audited by	
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Dart Aerospace Ltd

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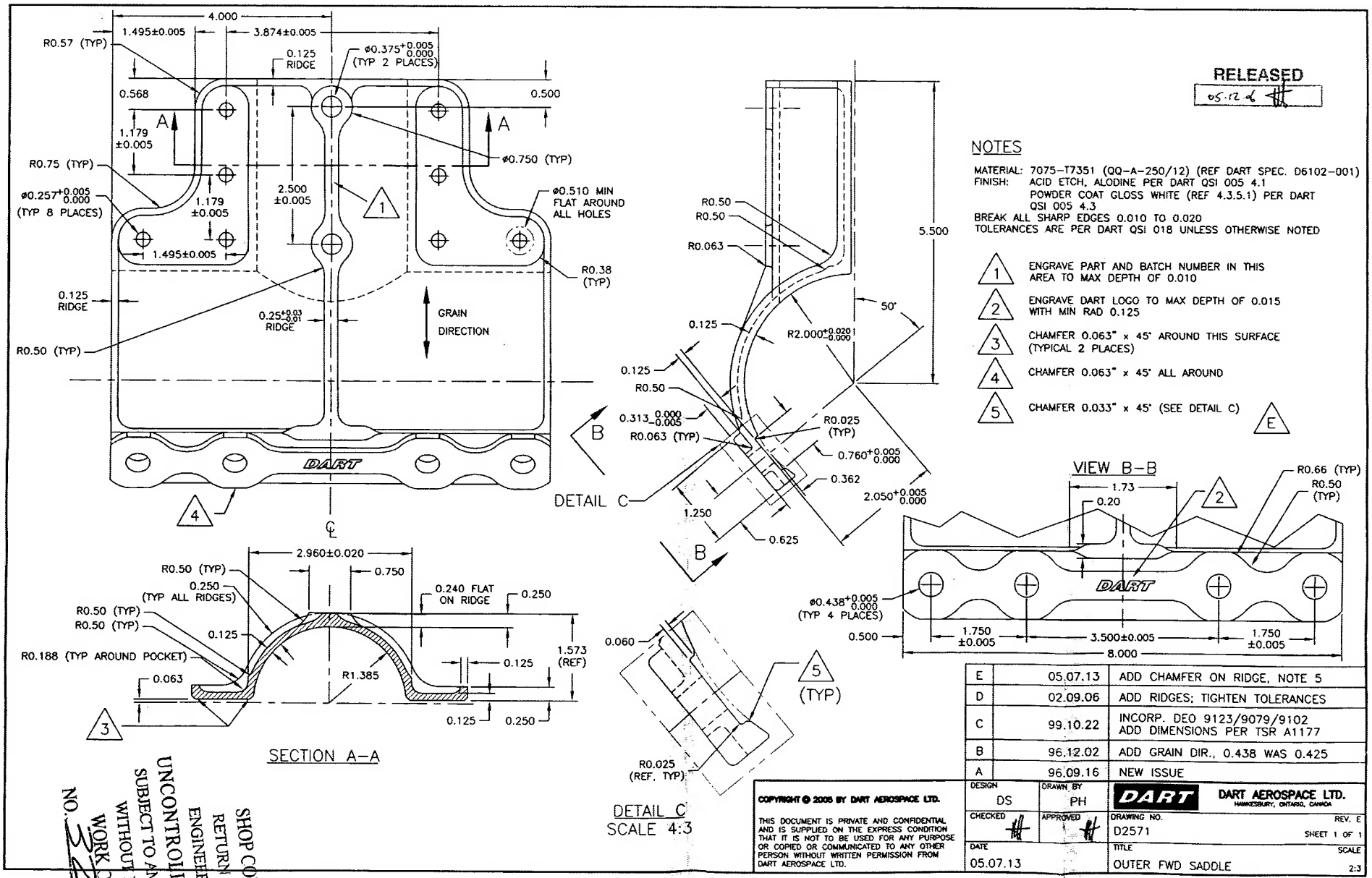

RELEASED
05-12-6

NOTES

MATERIAL: 7075–T7351 (QQ–A–250/12) (REF DART SPEC. D6102–001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2571	REV. E
DATE: 05.07.13		TITLE: OUTER FWD SADDLE	SCALE: 2:3
			SHEET 1 OF 1

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 32016

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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